

Shift NOV. 11

Work Order ID 152674

152674

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Item ID: D5393-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut
 Start Date: 11/4/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/7/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: 16-11-03 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5393	A

110	Small Fab	0.00							
110									
Large Fab	Memo	0.14							
Large Fab	1- Cut to length								
	2- Chamfer ends as per dwg								
	3- Deburr								

1 FF NOV 07 2016

120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 38
 9-88
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WAOOZ</u>	0.00				1			
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

16-11-07

16/11/8

16-11-7

Picklist Print

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Work Order ID: 152674

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Parent Item: D5393-1

D5393-1

Parent Item Name: Strut

Start Date: 11/4/2016

Required Date: 11/7/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.02.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.049

Purchased

No

f

49.9630

1.789474

M304TR0 500W 049

FF

NOV 07 2016

304 RD Tube .500 x .049W

Location

Loc Qty

Loc Code

GA002

49.963047

M127937

1.1741

M132872

15.104736

M135325

33.684211

1.789474

8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

0.030 x 45°
CMF, 2 PL

Ø

20.40

Ø0.500
REF

0.049
REF

D5393-1 STRUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152674
WIP 16.11.03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF. DART SPEC M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

RELEASED
2016-02-08

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D5393	REV. A
MFG. APPR.	DD	TITLE	SHEET 3 OF 3
APPROVED	HS	SCALE	
DE APPR.	DS	STRUT ASSEMBLY	
DATE	16.01.27	NTS	

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8 7 6 5 4 3 2 1